

Data

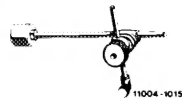
Roughness of camshaft bearing journals			0.003	
Permissible runout of center bearing journals and camshaft sprocket seat when mounting camshaft at outer bearing journals	Camshaft code number ¹⁾	00	05, 08	
	Camshaft sprocket seat	0.020	0.025	
	2nd bearing point	0.030	0.030	
	3rd bearing point	0.025	0.030	
Scleroscope hardness of cams		70—82	64—75	
Bearing points (Fig.)		a	b, c and d	
Standard dimension	Camshaft bearing dia.	<u>35.00</u>	<u>46.50</u>	<u>49.00</u> ²⁾
		35.02	46.52	49.02
	Journal dia.	<u>34.95</u>	<u>46.45</u>	<u>48.95</u> ²⁾
		34.93	46.43	48.93
Intermediate stage	Camshaft bearing dia. (color code grey)	<u>34.90</u>	<u>46.40</u>	<u>48.90</u> ²⁾
		34.92	46.42	48.92
	Journal dia.	<u>34.85</u>	<u>46.35</u>	<u>48.85</u> ²⁾
		34.83	46.33	48.83
Repair stage I	Camshaft bearing dia. (color code red)	<u>34.75</u>	<u>46.25</u>	<u>48.75</u> ²⁾
		34.77	46.27	48.77
	Journal dia.	<u>34.70</u>	<u>46.20</u>	<u>48.70</u> ²⁾
		34.68	46.18	48.68
Width A of journal a (Fig.)		<u>34.00</u> 34.04	—	
Bearing play	radial	0.050—0.084		
	axial	0.07—0.15		

¹⁾ Code number is punched into rear end of camshaft.

²⁾ Camshaft bearings and journal dia. on engine 617.950 (USA) model year 1980 with increased output and engines 617.951/952.

Special tool

Dial gage holder for end play of camshaft (2 each)



363 589 02 21 00

Conventional tool

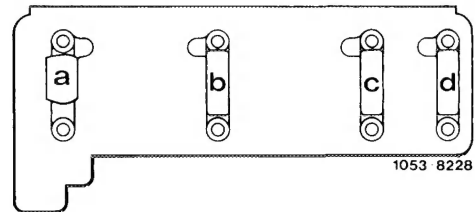
Dial gage A 1 DIN 878

e.g. made by Mahr, D-7300 Esslingen
Order No. 810

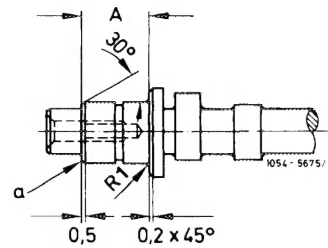
Note

In the event of repairs, regrind camshaft in accordance with available camshaft bearings.

Camshaft bearing journals are not hardened.

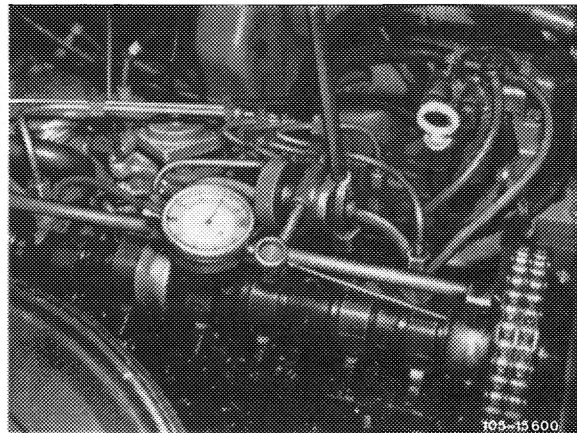


If dimension A is exceeded when grinding 1st bearing journal, also regrind face a.



Measuring end play

- 1 Screw on dial gage holder with threaded sleeve at front left.
- 2 Position dial gage at approx. 3 mm preload against thrust flange of camshaft.
- 3 Push camshaft toward the rear and set large needle to zero.



- 4 Push camshaft forward and determine end play.

Note: If the end play is too low, touch up 1st camshaft bearing at its face surfaces (arrow).

If the end play is too high, regrind face a on 1st bearing journal of camshaft.

